

Date: Tuesday, 14/10/2008 10:19:16 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y LH
Job Number :	42560		
Estimate Number :	13306		
P.O. Number :		Part Number :	D412769043
This Issue :	14/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-1 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	40918	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JO 08.10.14</u>	Due Date :	21/10/2008
Comment :	Est rev A 08-05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec Est Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC		
		Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D3782045	Back Leg Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Back Leg Assembly batch: <u>42152</u>	
3.0	D3782041	Front Inboard Leg Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>42149</u>	
4.0	D3782043	Front Outboard Leg Assembly, LH
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Front Outboard Leg Assembly, LH batch: <u>42150</u>	
5.0	D3783041	Lateral Brace Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Lateral Brace Assembly batch: <u>B42725</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 10:19:16 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3783043

Longitudinal Brace Assembly

A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B 42640

FF 08/10/23

①

7.0

D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B 42551

8/10/21

SLP

8.0

D3784041

Seat Support Assembly, Center

A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: 42641

FF 08/10/23

①

9.0

D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: 42519

50

10.0

D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: 42521

SL

11.0

D37661

Front Rail, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B 40863

SL

12.0

D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B 40865

8/10/21

SL

②

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Upper Rail
batch: B410866

SL

14.0	AN415A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M108868

8/10/21

SL

15.0	AN45 13A	EYE BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
EYE BOLT
batch: M109013

FF 08/10/23

①

16.0	AN510A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M108990

SL

17.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M108164

SL

18.0	AN960JD10	Washer
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)
Washer
batch: M109059
(or NAS1149D0363J) batch: _____

SL

19.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M108827
(or NAS1149D0463J) batch: _____

8/10/21

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD516	Washer
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M109037

(or NAS1149D0568J) batch: _____

SP

21.0	AN52510R24	Screw
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108879

SP

22.0	MS21042L3	Nut
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M109037

SP

23.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108145

SP

24.0	MS21042L5	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108827

1/10/21

SP

SP

25.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/10/24

26.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

500/6024 FF

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation: Description :

27.0 POWDER COATING POWDER COATING



M 106442



(1X)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when powder coating

3- Powder coat remaining of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 °C
8:30

M-L 08/10/25

28.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/10/27

29.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0 D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B42563

FF 08/10/29

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: B40869

SC

32.0 D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B41084

8/10/24

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D37743	Seat Back, LH/RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: B40868

SP

34.0	AN525 10R22	Screw
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Screw
batch: M109267

SP

35.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Washer
batch: M104885
(or NAS1149D0332J) batch: M105793

SP

36.0	MS21042L3	Nut
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Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)
Nut
batch: M109031

SP

37.0	AN35A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M100188

8/10/21

SP

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1- install remaining parts as per dwg D412-769-1

FF 08/10/27 (1)

39.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 08/10/29 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 42560

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: P0042983

DS 08/10/2008 EL

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-04

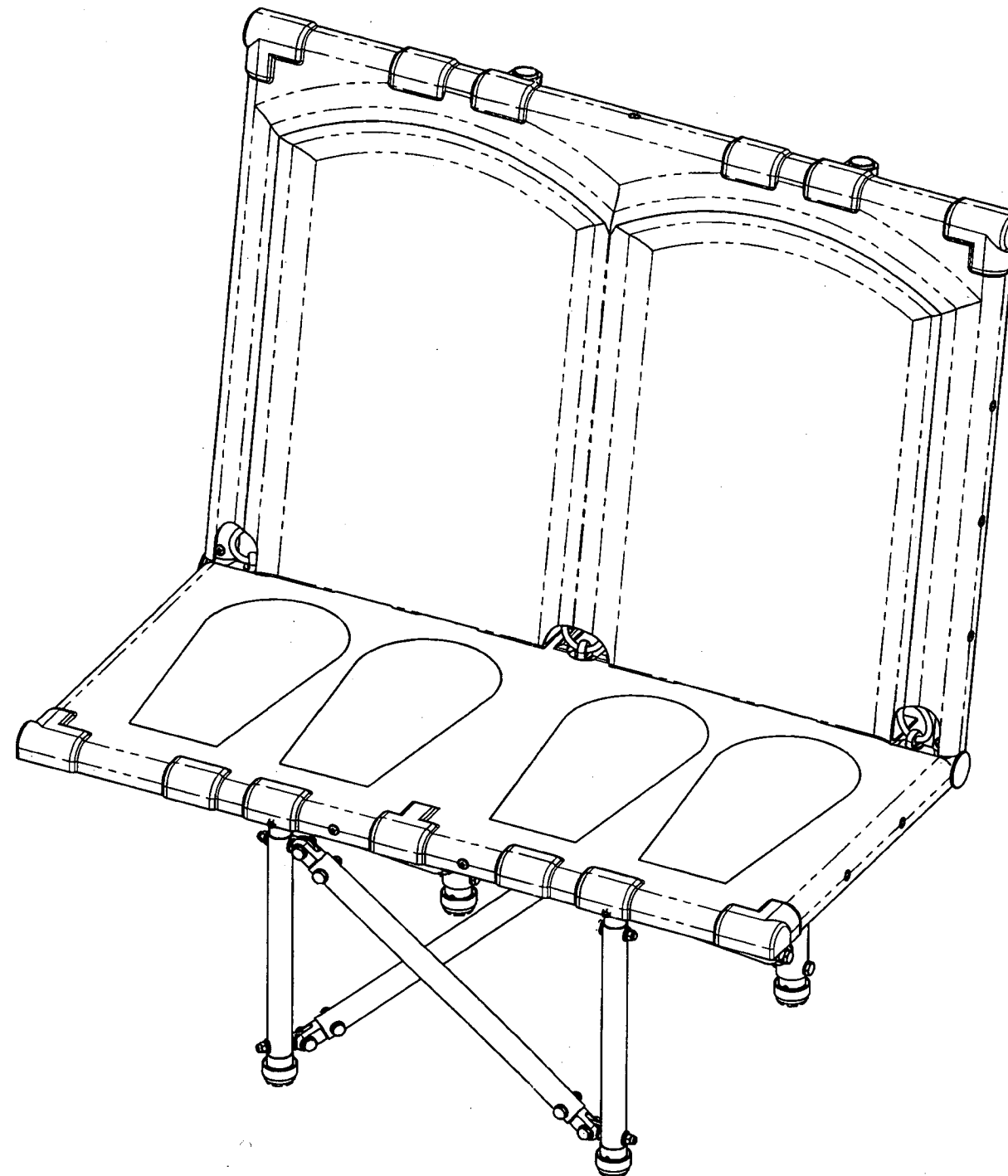
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



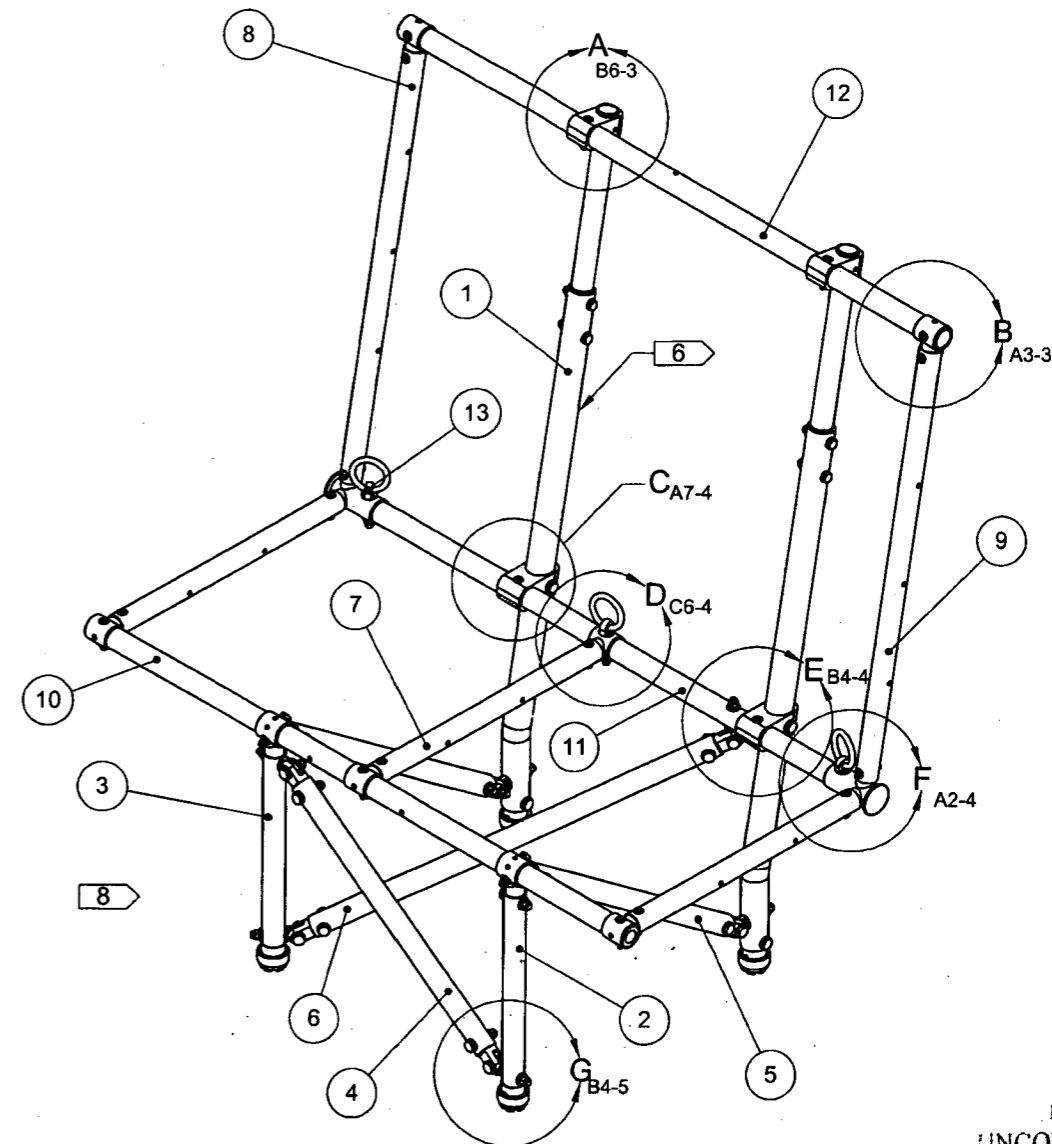
D412-769-043 AFT FACING SEAT ASSY, LH

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WITHOUT NOTICE
WORK ORDER

RELEASED
08.07.09 1400 4250

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	AT	DRAWING NO.	REV. B
MFG. APPR.	AT	D412-769-1	SHEET 1 OF 7
APPROVED	AT	TITLE	SCALE
DE APPR.	AT	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



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D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
NO. 42560
08.07.09/10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 - 7) WEIGHT: 30.0 lbs
 - 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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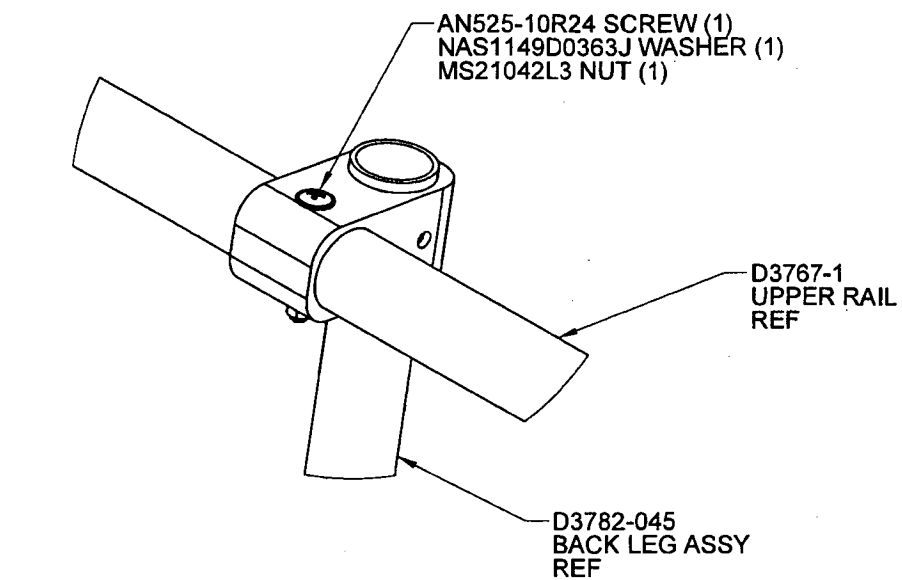
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D

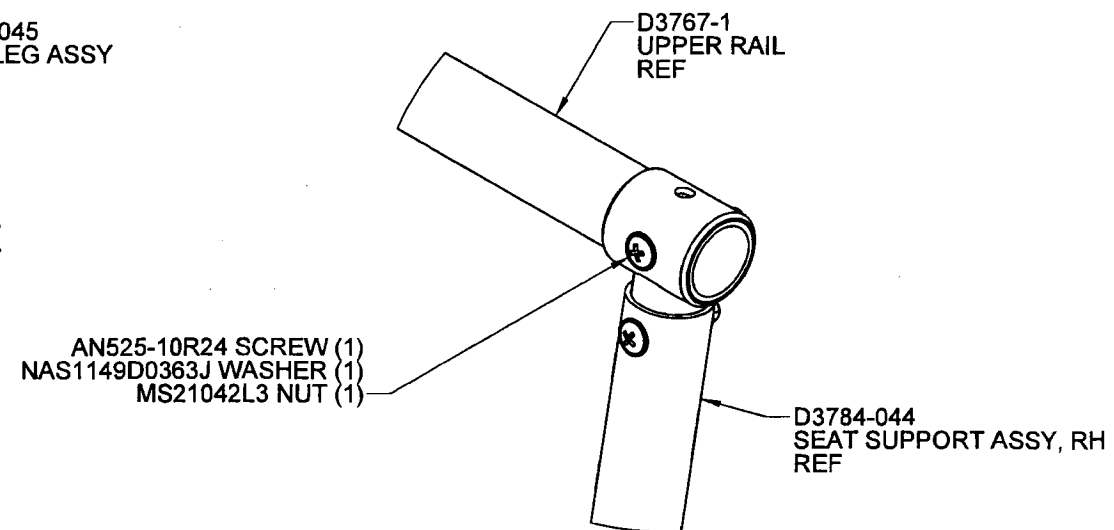
C

B

A



DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

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NO. 4250

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07.09.11

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DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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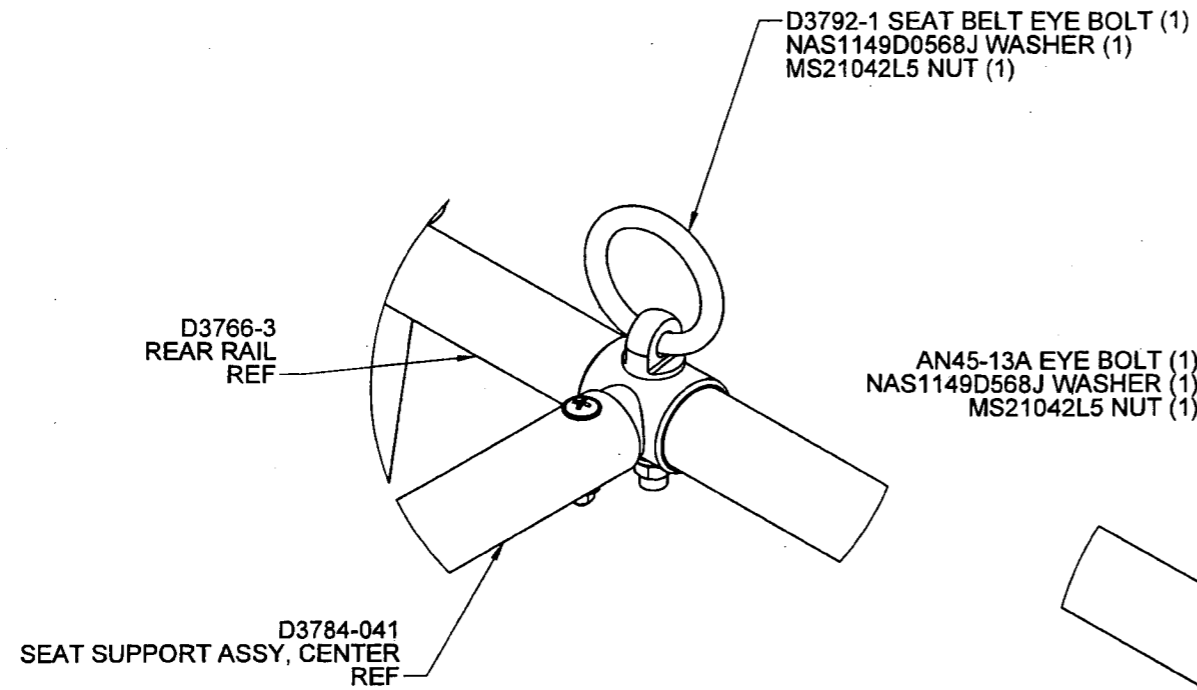
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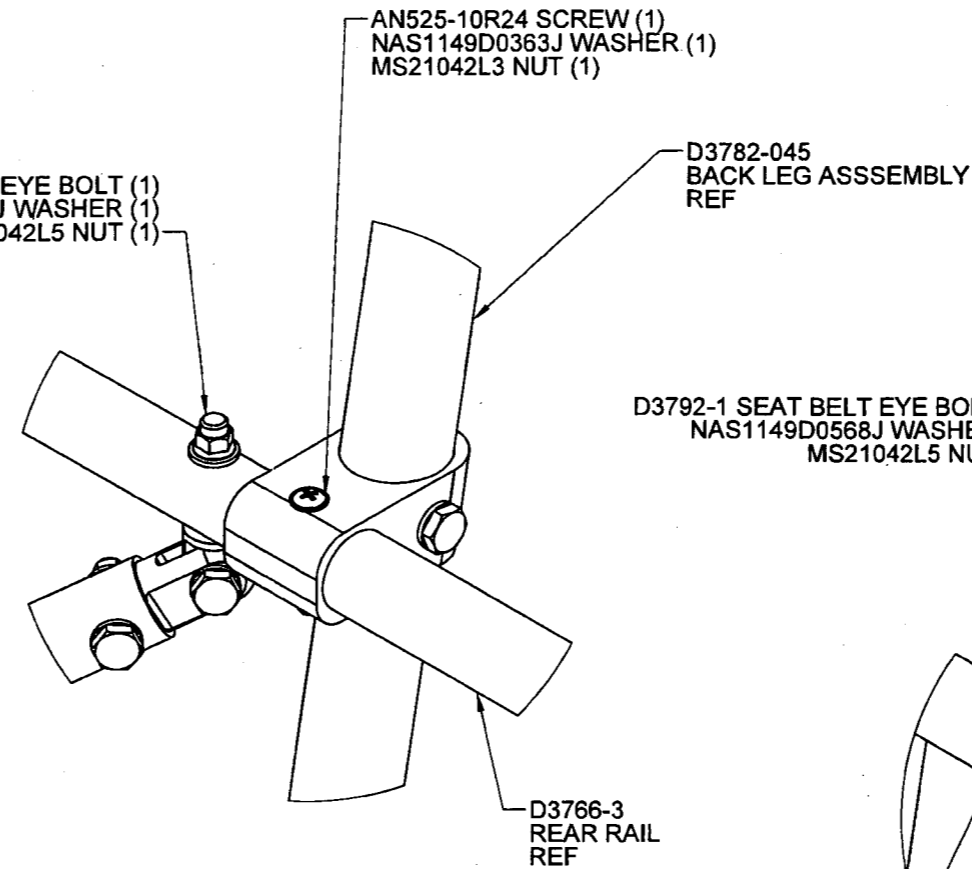
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D
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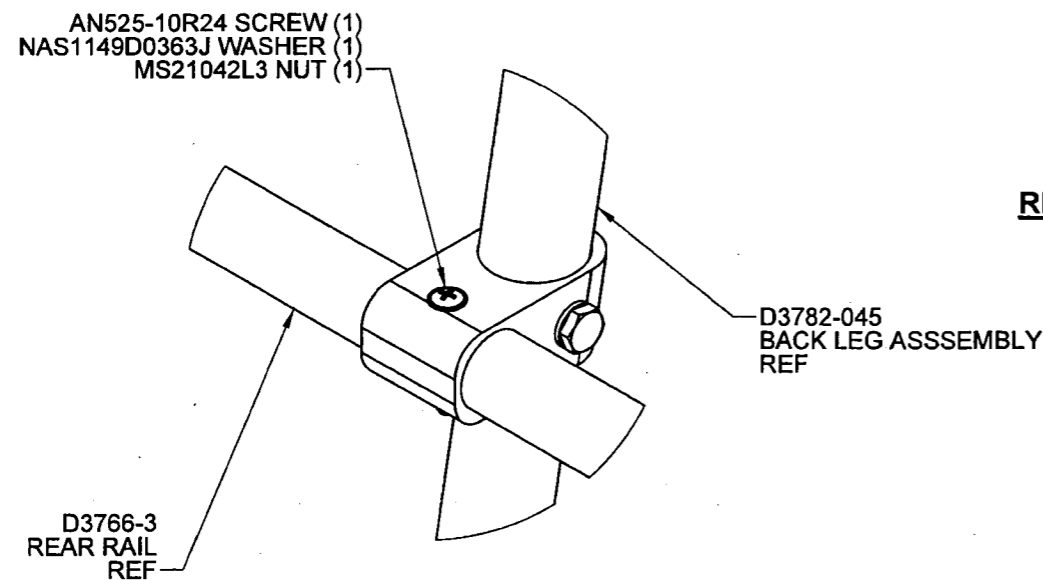
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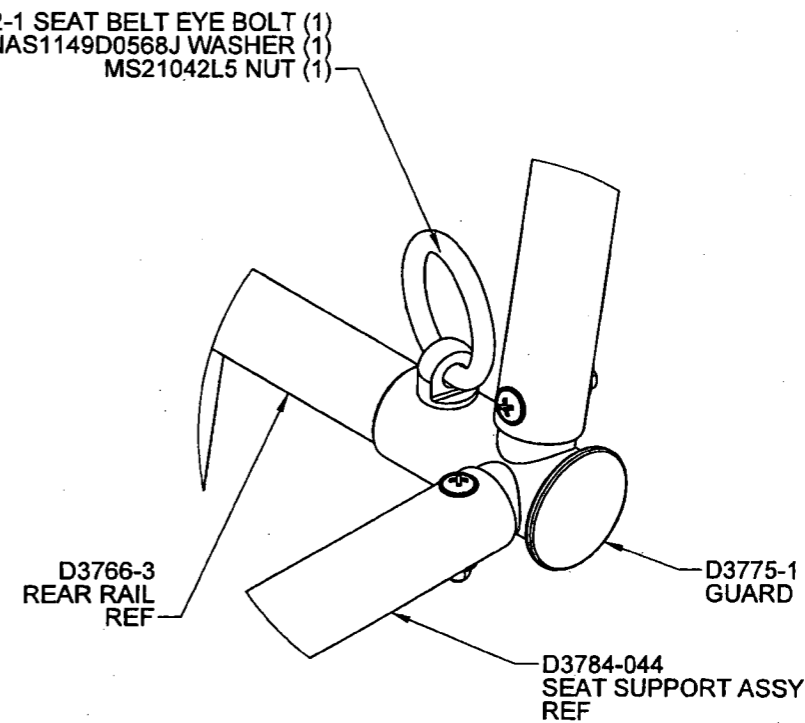
DETAIL D C2-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT



DETAIL E C1-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT



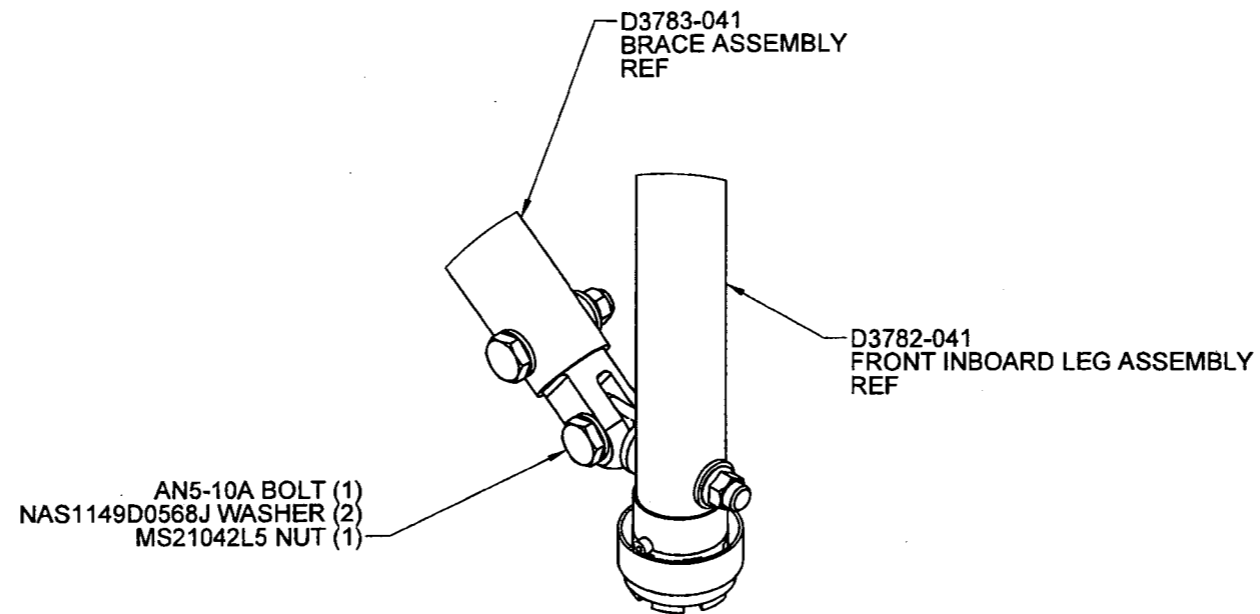
DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

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08.07.08/11/14

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DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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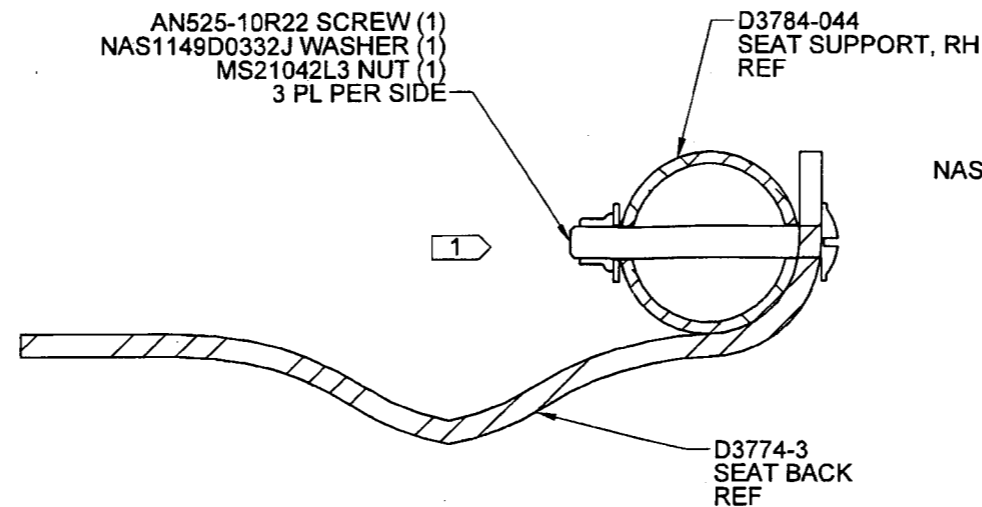
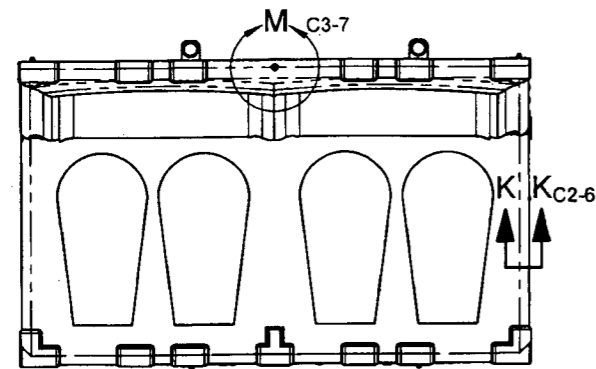


DETAIL G_{B2-2}
BRACE ATTACHMENT
 6 PL

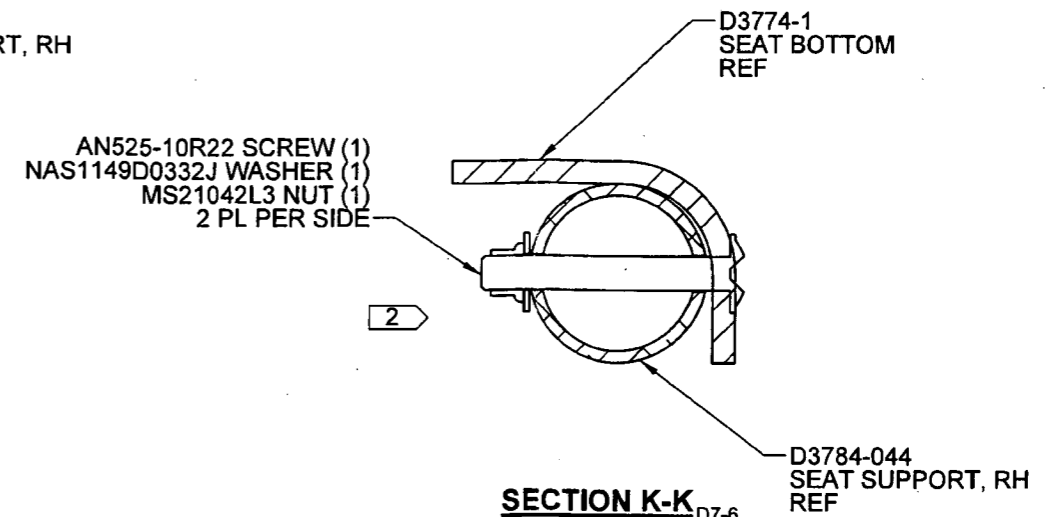
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 WORK ORDER NO. 42500

RELEASED
 08.07.09

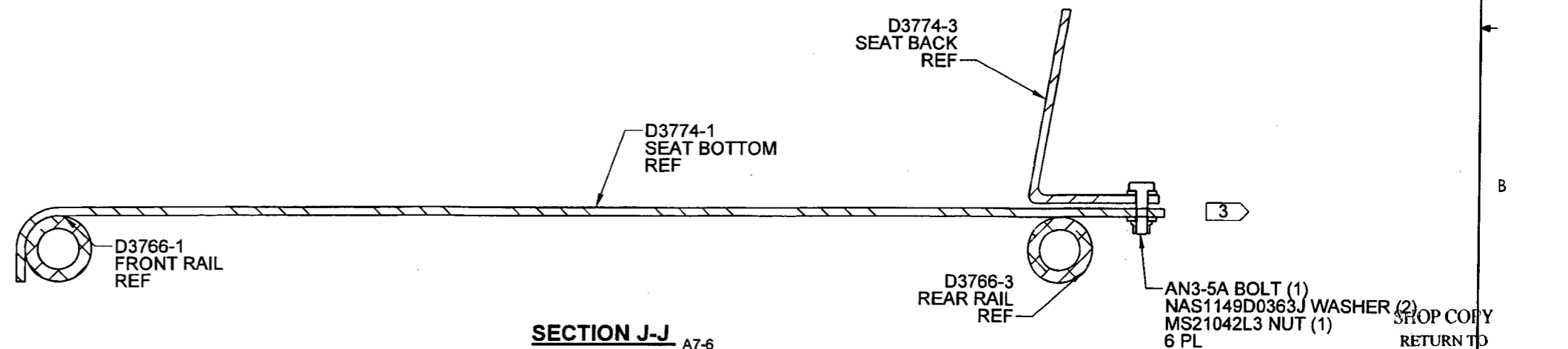
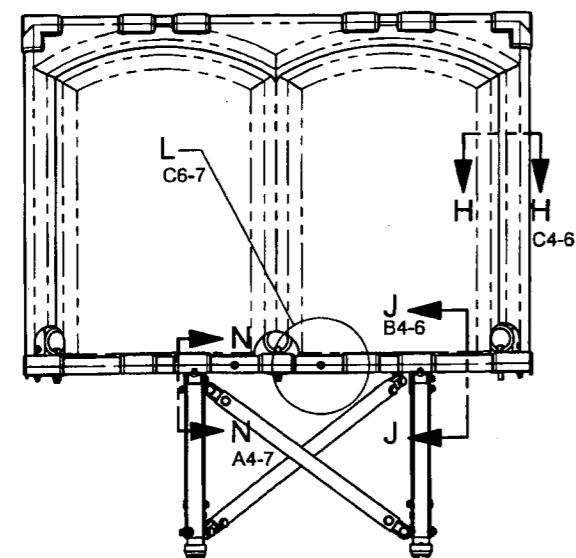
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	MS	D412-769-1	SHEET 5 OF 7
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SECTION H-H B7-6



SECTION K-K D7-6

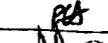
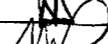
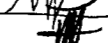


SECTION J-J A7-6

- NOTES:**
- 1) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
 - 2) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
 - 3) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

RELEASED
08-05-09 1174

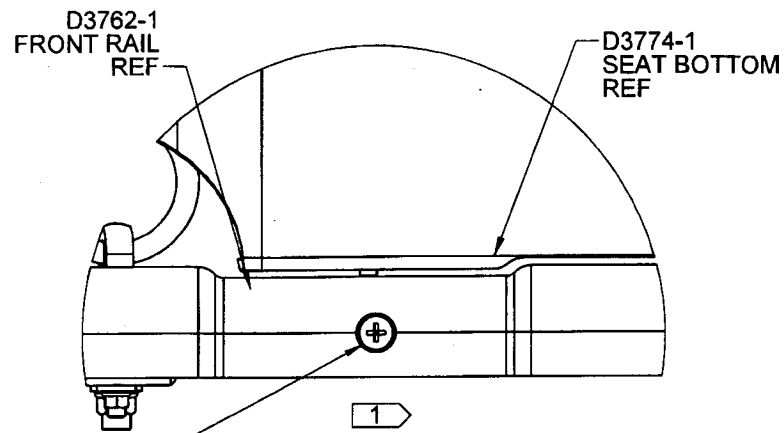
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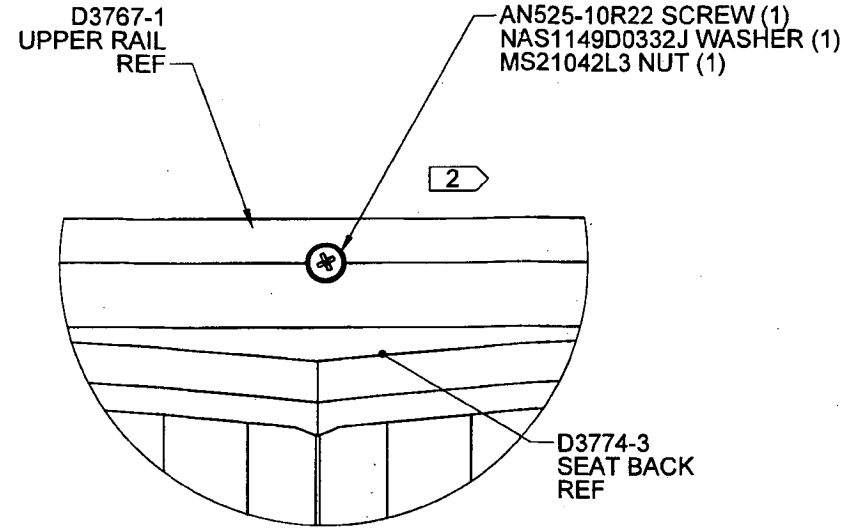
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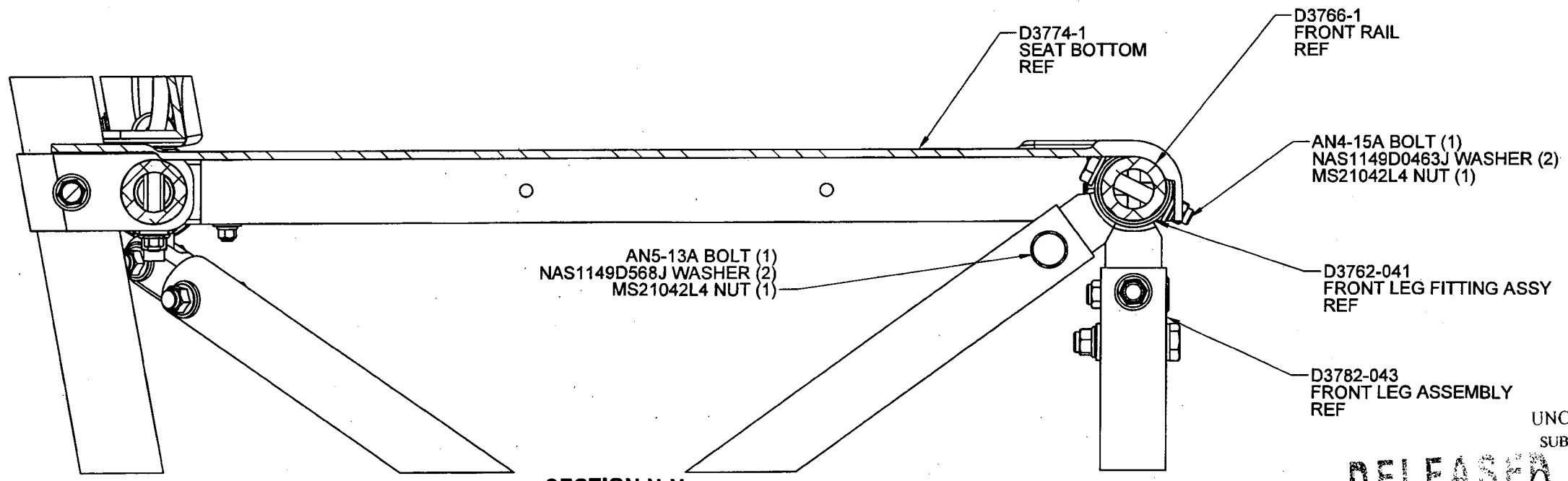


AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)

DETAIL L_{A7-6}
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M_{D7-6}
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N_{A8-6}
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

NOTES:
1) TRANSFER DRILL Ø0.201 FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL Ø0.201 FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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8 7 6 5 4 3 2 1